

150 x 049

Work Order ID 74439

Thursday, September 29, 2011 2:40:50 PM



Page 1

Item ID:	D3286-3	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Spacer					
Start Date:	9/29/2011	Start Qty:	80.00		Cust Item ID:	
Required Date:	10/20/2011	Req'd Qty:	80.00		Customer:	
Reference:						

Approvals:	Process Plan: <u>MLJ</u>	Date: <u>9/29/11</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3286	Rev A								

100		0.00							
	Hardinge CNC LATHE SMALL								
Hardinge	Memo	0.00							
Hardinge CNC Lathe Small	Turn blanks as per Folio FA434 and Dwg D3286 Deburr as [per Dwg D3286		SL ²⁰	11/10/03					

80

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									

SL²⁰ 11/10/03

80

120	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									

SL²⁰ 11/10/04

80

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Thursday, September 29, 2011 2:40:50 PM

**Setup Start**

Stop

[illegible]**Cust Item ID:**

Customer:

Reference:

Run Start



Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____



**Insp.
Stamp**

0.00



Packaging

Memo

0.00

Packaging

STOCK IN SKIDTUBE CELL

140

0.00




QC

Memo

0.00

Quality Control

no BO BE 11/05/05

n/10/11 

MF

11-10-6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Thursday, September 29, 2011 2:40:56 PM

Page 1

Work Order ID: 74439

Parent Item: D3286-3

Parent Item Name: Spacer



Start Date: 9/29/2011

Required Date: 10/20/2011

Start Qty: 80.00

Required Qty: 80.00

Comments: IPP A 04.07.14 New issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TR0.500W.049		Purchased	No			110	f	394.5211	0.3417	28.77474			
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304 RD Tube .500 x .049W



SL

11/10/03

Location

Loc Qty

Loc Code

MAT017

394.521058

111814

2.23

115010

145.421058

117598

66.87

✓ 119087

180

27.333

M304TR0.500W.049

M119087

M304TR0.500W.049

M119087

M304TR0.500W.049

M119087

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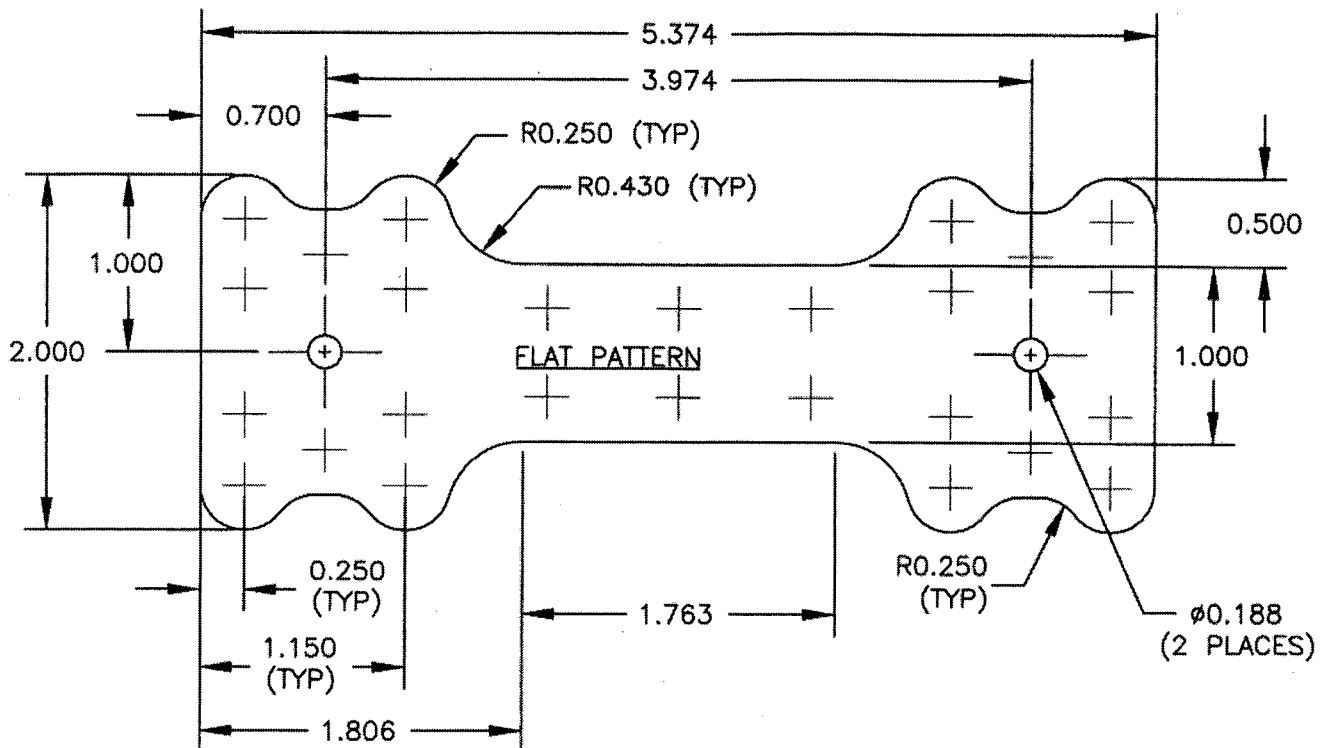
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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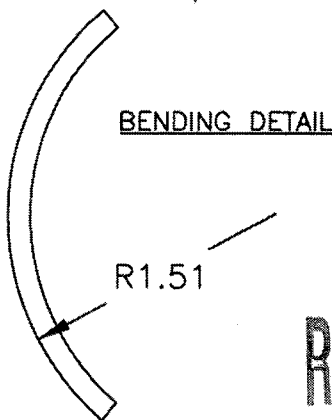
NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3286	REV. A SHEET 1 OF 2
DATE 04.05.06		TITLE GROUND HANDLING PARTS	SCALE 1:1
A	04.05.06	NEW ISSUE	



+ INDICATES LOCATION OF RIVET HOLES. SHOWN FOR REFERENCE ONLY, DO NOT DRILL.



RELEASED
04.06.22

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 74439

M.L.J
9/29/11

D3286-1 DOUBLER

- 1) MATERIAL: AISI 304/316 SS SHEET 0.125" THICK
(REF DART SPEC. M304S11GA)
- 2) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

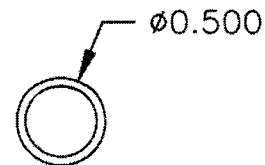
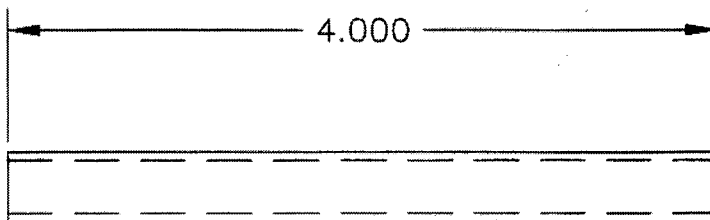
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3286	REV. A SHEET 2 OF 2
DATE 04.05.06		TITLE GROUND HANDLING PARTS	SCALE 1:1



D3286-3 SPACER

- 1) MATERIAL: AISI 304/316 SS TUBING, 0.500 O.D. x 0.049 WALL
(REF DART SPEC. M304TR0.500W.049)
- 2) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED
04.06.22 *#*

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74439

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